

90719

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 90719

September-24-12 2:36:40 PM

90719

Page 2

Item ID: D3065-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Leg Assembly Hi

Stop ***NS2***

Start Date: 9/24/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/12/22

MK
12-1222

Picklist Print

September-24-12 2:36:39 PM

Page 1

Work Order ID: 90719

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/24/12

Required Date: 10/19/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	61.0000	1	20		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		61							
				74497		1							
				81303		1							
				83733		29							
				88825		30							
D3065-3 Step Spacer		Manufactured	No			100	Each	62.0000	1	20		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		62							
				69827		1							
				73290		4							
				75152		14							
				83734		12							
				83873		1							
				88826		30							
D3065-5 Step Leg		Manufactured	No			100	Each	120.0000	2	40		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		120							
				67222		1							
				73289		19							
				88827		80							
				89239		20							

B90766

B91635

B89939

B90073

Picklist Print

September-24-12 2:36:40 PM

Page 2

Work Order ID: 90719

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/24/12

Required Date: 10/19/12

Start Qty: 20.00

Required Qty: 20.00

D3065-7
Step Spacer

Manufactured No

100 Each 91.0000 1

20 *12/11/14*

Location Loc Qty Loc Code

GA	91	
73291	7	
74499	1	
78666	4	
83738	1	
85471	8	
88828	30	
89972	40	

690520

390657 (20x)

MS20470AD4-4
Rivet, Universal Head

Purchased No

100 Each 7,382.0000 30 600

12/11/15

Location Loc Qty Loc Code

ST313	2662	
122027	2600	
122063	62	
ST319	4720	
116188	136	
116391	66	
118614	884	
119109	26	
121011	5	
121556	603	
121652	3000	

M123352 (600x)

September-24-12 2:36:40 PM

Shop Packet Print

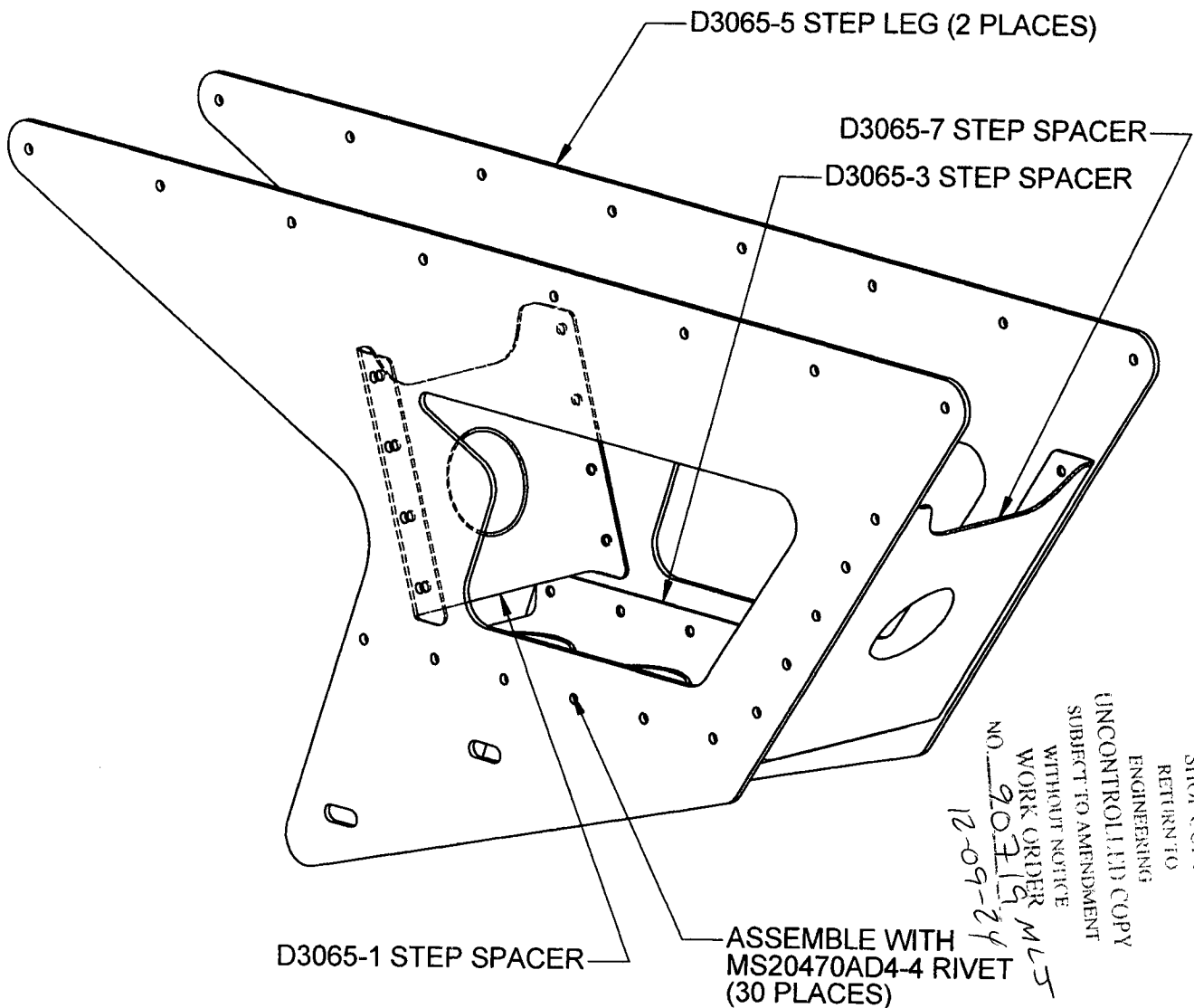
Page 2

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



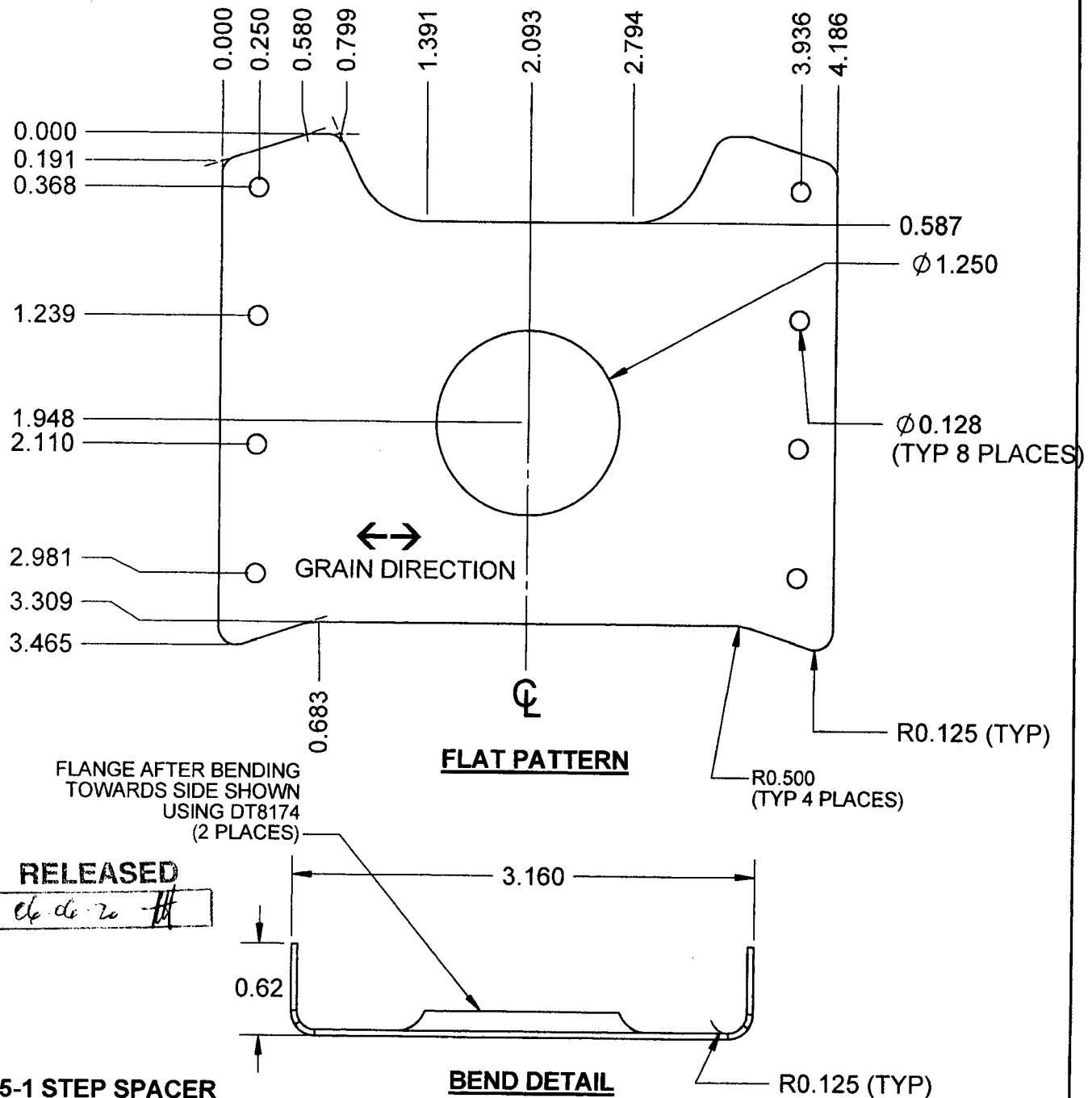
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER****BEND DETAIL**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

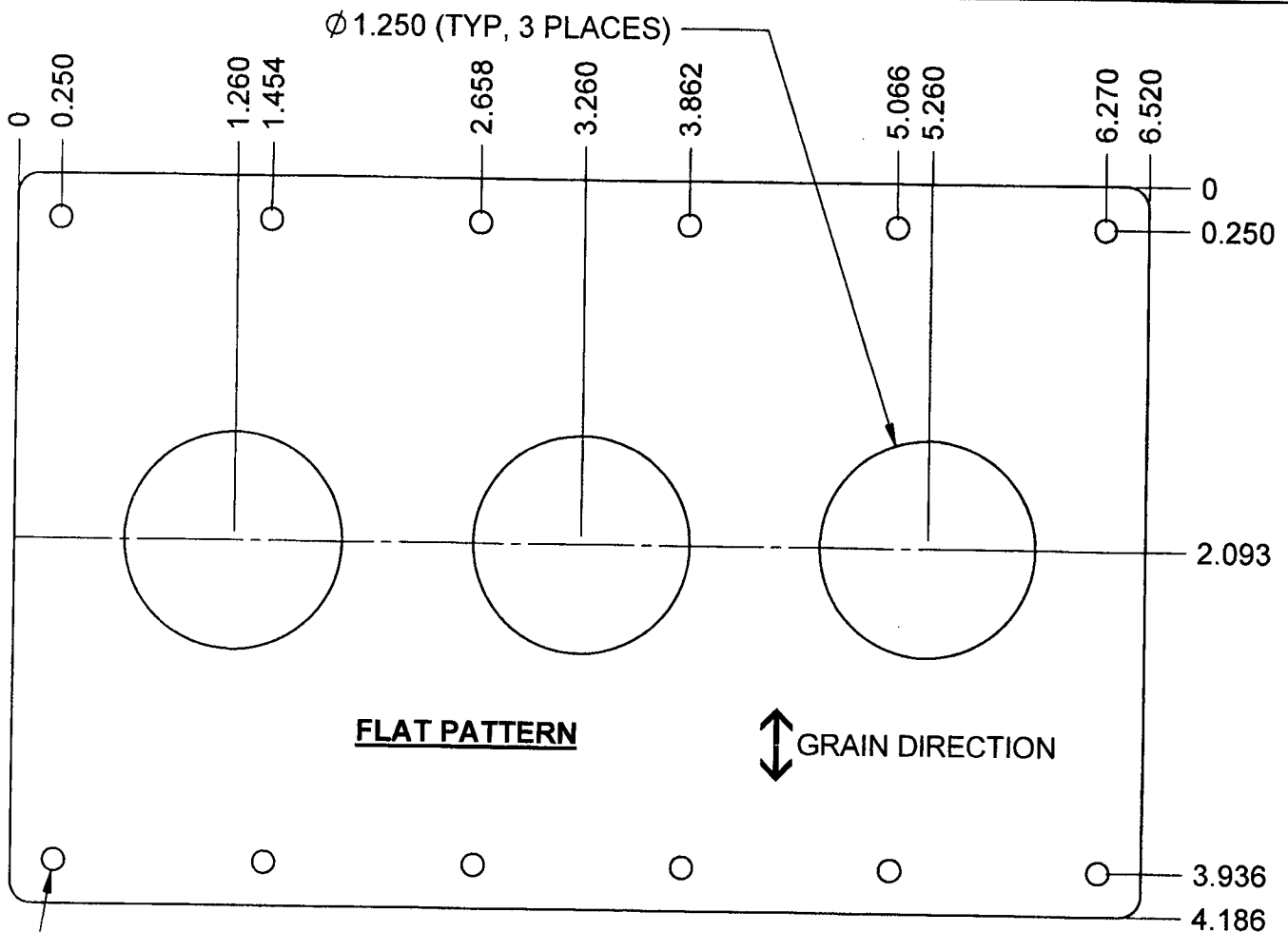
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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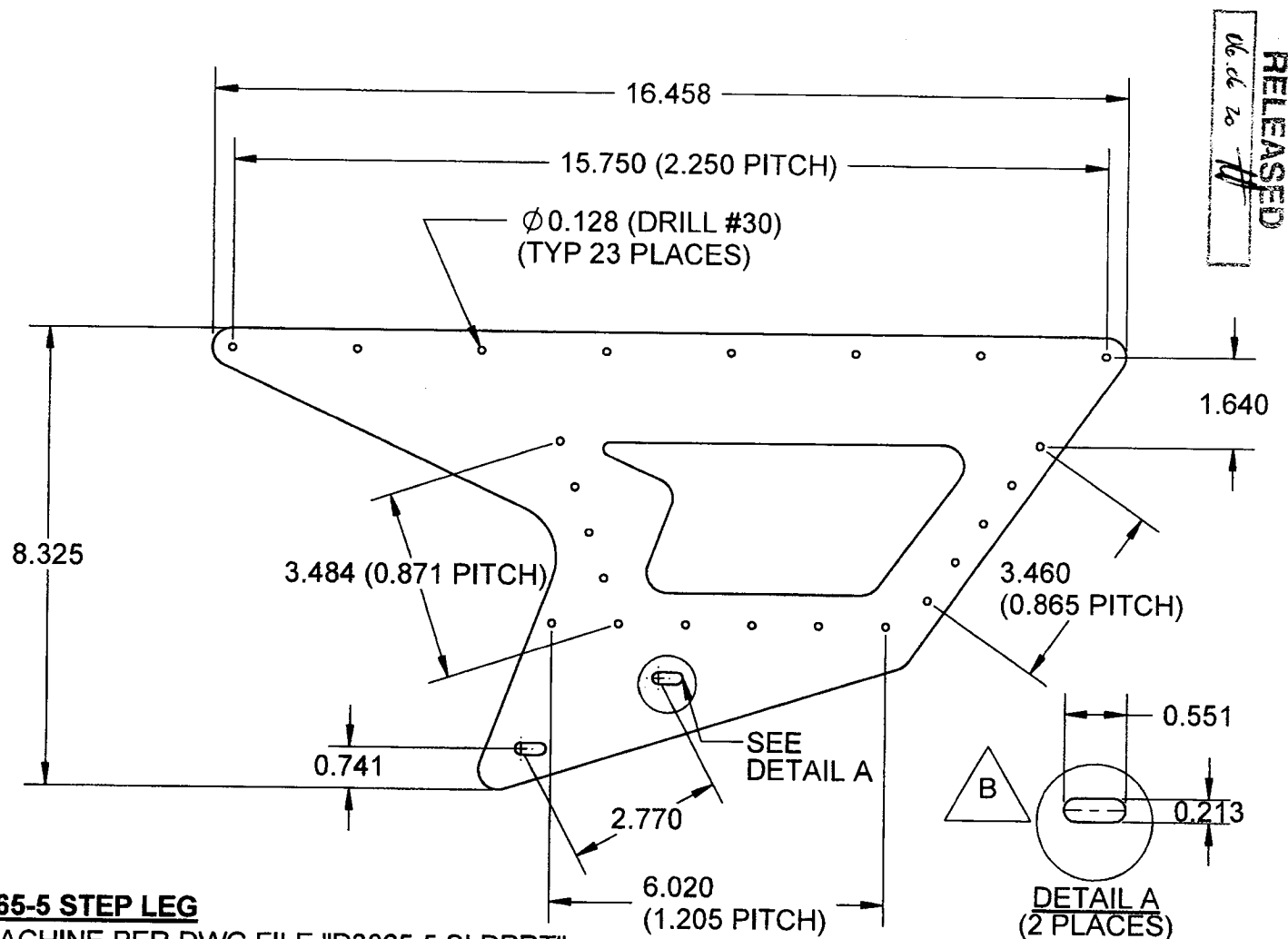
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90719

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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO. D3065
		REV. B
		SHEET 4 OF 5
		SCALE 1:3
		TITLE STEP LEG ASSEMBLY

**D3065-5 STEP LEG**

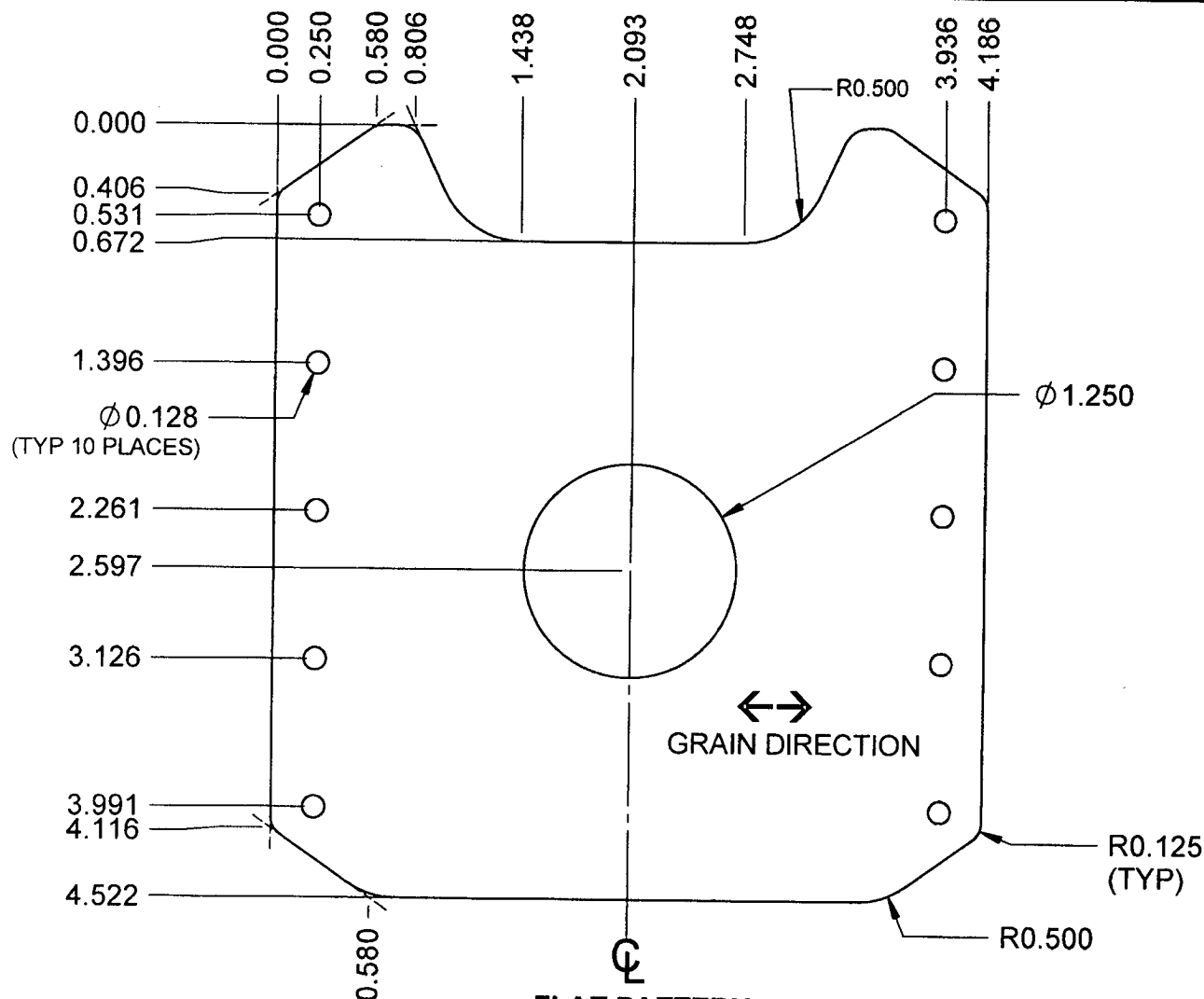
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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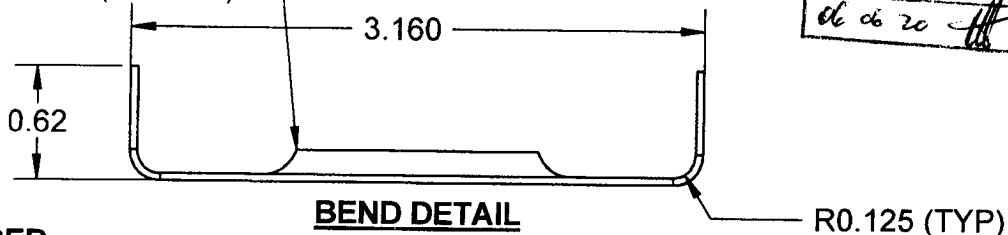
DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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